

Work Order ID 62567

Monday, October 04, 2010 1:13:21 PM



Page 1

Item ID: D4093-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 10/5/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-10-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4093	A

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

750 x 6"

CUT AS DWG

DWG REV: A

PROG REV: A

DEBURR

MATERIAL CERTIFICATION

REQ'D UPON DELIVERY

10-10-04

10-10-5

②

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62567

Monday, October 04, 2010 1:13:21 PM

Page 2

Item ID: D4093-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 10/5/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 2.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00 4	S 10/10/05			(x2)			
132  Small Fab Small Fab	Small Fab DRILL AS PER DWG Memo	0.00 0.00	J.F.S. 10/10/22			(x2)			
135  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 10/10/22			(x2)			3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62567

Monday, October 04, 2010 1:13:21 PM

Page 3

Item ID: D4093-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 10/5/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 PR 10-10-28.

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M 1152011 START. 3:40
OVERT. 3:30
FINISH 4:10.

2 PR 10-11-1.

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2) Jll 10/11/02

2 d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62567

Monday, October 04, 2010 1:13:21 PM



Page 4

Item ID: D4093-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 10/5/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PMP
62803

0.00

Packaging

Cery 11/2 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

chu 10/11/02
mf
10-11-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 1:13:20 PM

Page 1

Work Order ID: 62567



Parent Item: D4093-3



Parent Item Name: Bracket

Start Date: 10/5/2010

Required Date: 10/18/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-10-04 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No			100	f	42.0800	1	2			
										<u>B310-10-5</u>			
6061T6 BAR .750 X 6.00													

B10-10-5

Location

Loc Qty

Loc Code

MAT03

42.08

112567

42.08

112567

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62567
Description: BRACKET		Part Number: D4093-3
Inspection Dwg: D4093-3 Rev: A		Page 1 of 2

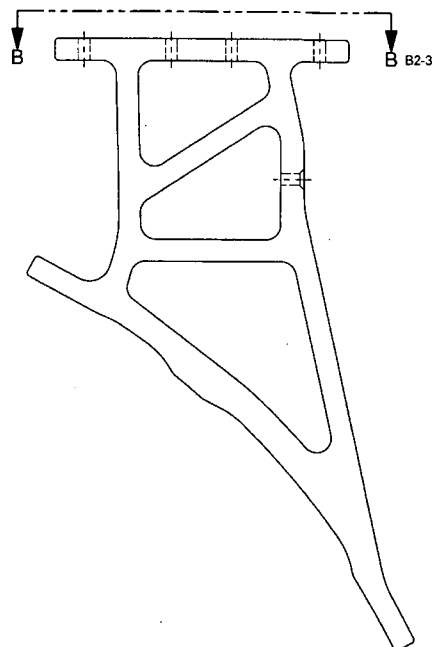
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

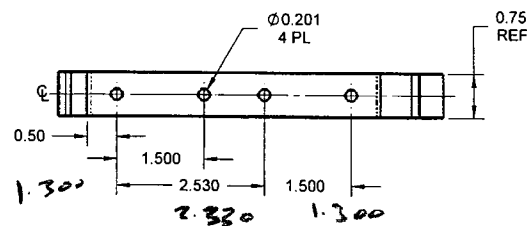
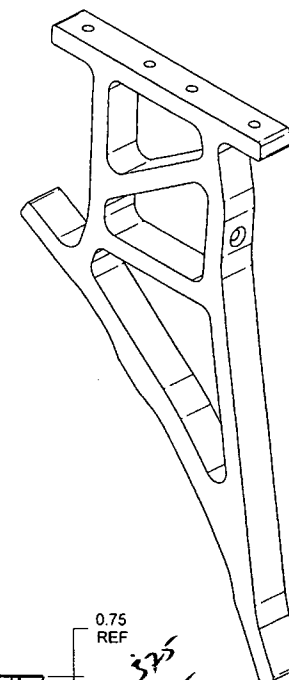
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.05	+/- .030	1.053	X		V HB02	
1.43	+/- .030	1.429	X		V	
3.86	+/- .030	3.856	X		V	
4.04	+/- .030	4.039	X		V	
5.03	+/- .030	5.023	X		V	
.38	+/- .030	.379	X		V	
1.48	+/- .030	1.480	X		V	
2.18	+/- .030	2.183	X		V	
.40	+/- .030	.398	X		V	
3.43	+/- .030	3.431	X		V	
3.80	+/- .030	3.815	X		V	
7.08	+/- .030	7.086	X		V	
10.45	+/- .030	10.45	X		V	
.38	+/- .030	.378	X		V	
4.71	+/- .030	4.71	X		V	
.51	+/- .030	.509	X		V	
.60	+/- .030	.609	X		V	
1.47	+/- .030	1.47	X		V	
.38	+/- .030	.377	X		V	
.75	+/- .030	.743	X		V	
2.39	+/- .030	2.391	X		V	
0.50	+/- .030	.500	X		V	
1.500	+/- .010	1.502	X		V	

Measured by: <u>AB/TJS</u>	Audited by: <u>8</u>	Prototype Approval:	N/A
Date: <u>10-10-5</u>	Date: <u>10/10/05</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



#62507



SECTION VIEW B-B B5-3

D4093-3 BRACKET

RELEASED
2010-09-23

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.96 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4093	SHEET 3 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BRACKET	NTS
DATE	10.09.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

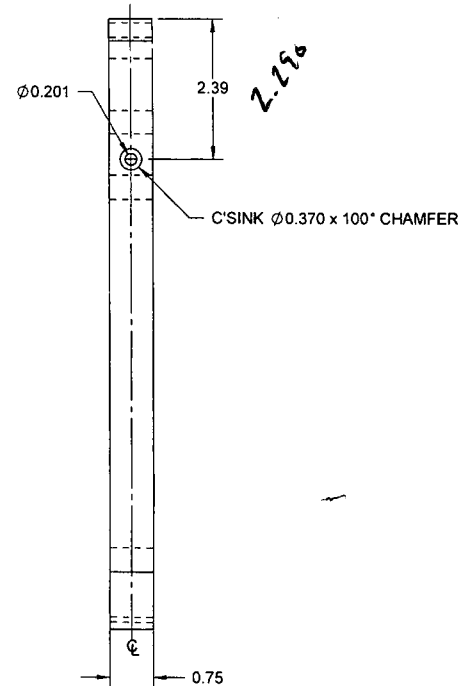
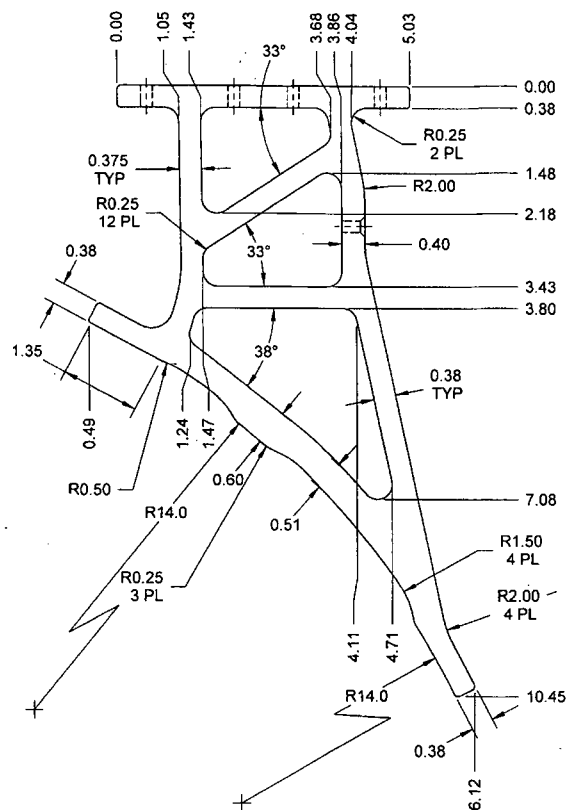
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#62567
2.256

D4093-3 BRACKET

RELEASED
2010-09-23
WD

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	WD	DRAWING NO.	REV. A
MFG. APPR.	WD	D4093	SHEET 4 OF 5
APPROVED	WD	TITLE	SCALE
DE APPR.	WD	BRACKET	NTS
DATE	10.09.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Receiving Report

Date: 9/9/02

Batch No: M112067

Supplier: MAGNA

Dart P/O: 10312

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☒ N/A ☐
 QC6 Inspection ☒ 8 N/A ☐
 Work Order 09109102 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061	TGB-200x0400	40	0	0	40	
M6061	30181x0400	40	0	0	40	
M6061	TGB1-200x0400	40	0	0	40	

M6061 TGB-200x0400

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

09/09/02

RCR 10312

CR

Location

M 3045126A

69

0

0

69

Currency	Sales Person	Ship Via	F.O.B.	Terms
CANADIAN DOLLARS	ERYCK BLAIS	NIR:R-557065-1	PREPAID	NET 30 DAYS

Ln	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
				ALUMINUM FLATS			
		3	PC	AFL 6061 T6 3/4" x 6" x R/L L030012 20' 3 PC/318 LB	3 UN	215.00	645.00
		2	PC	AFL 6061 T6 3/4" x 1" x R/L L026715 20' 2 PC/35 LB	2 UN	36.00	72.00
		3	PC	AFL 6061 T6 1" x 2" x R/L L026407 20' 3 PC/142 LB	3 UN	95.00	285.00
		2	PC	AFL 6061 T6 1/2" x 6" x R/L L027689 20' 2 PC/142 LB	2 UN	145.00	290.00
				ALUMINUM ROUND BAR			
		2	PC	ARB 6061 T6 3/8" x R/L L026602 20' 2 PC/5 LB	2 UN	6.00	12.00
				ALUMINUM SHEET			
		4	PC	ASH 6061 T6 .050" x 48" x 96" L029081 4 PC/92 LB	4 UN	92.00	368.00
		2	PC	ASH 6061 T6 .125" x 48" x 96" L030531 2 PC/115 LB	2 UN	202.00	404.00
				ALUMINUM SQUARE BAR			
		2	PC	ASQ 6061 T6 3/4" x R/L L020464 20' 2 PC/26 LB	2 UN	27.00	54.00
				STAINLESS ROUNDS			
		5	PC	SRB 303 1/2" x R/L L029043 12' 1" 5 PC/40 LB	5 UN	18.00	90.00
		7	PC	SRB 303 3/4" x R/L	7 UN	22.00	154.00

Purchase Order Receipt Listing

Page 1 of 2

September 2, 2009 11:34:03 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO10312 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless								
PO10312	1		M6061T6B0.750X06. f 000		9/04/09	9/02/09	60.0000	\$10.75	0.0000	0	\$645.00 ✓
CAD	No		6061T6 BAR .750 X f 6.00 112567		60.0000	LAVO01		\$645.00	0.0000	0	
	2		M6061T6B0.750X01. f 000		9/04/09	9/02/09	40.0000	\$3.00	0.0000	0	CD \$120.00
	No		6061-T6 Bar .750 x f 1.00 112567		24.0000	LAVO01		\$120.00	0.0000	0	
	4		M6061T6B0.750X00. f 750		9/04/09	9/02/09	40.0000	\$1.35	0.0000	0	\$54.00 ✓
	No		6061-T6 Bar .750 x f .750 112567		40.0000	LAVO01		\$54.00	0.0000	0	
	5		M6061T6B1.000X02. f 000		9/04/09	9/02/09	60.0000	\$4.75	0.0000	0	\$285.00 ✓
	No		6061-T6 Bar 1.00 x f 2.00 112567		60.0000	LAVO01		\$285.00	0.0000	0	
	6		M6061T6B0.500X06. f 000		9/04/09	9/02/09	40.0000	\$7.25	0.0000	0	\$290.00 ✓
	No		6061-T6 Bar .500 x f 6.00 112567		40.0000	LAVO01		\$290.00	0.0000	0	
	9		M6061T6R0.375 f		9/04/09	9/02/09	40.0000	\$0.50	0.0000	0	\$20.00 CD
	No		6061-T6 Round Bar f .375" 112567		24.0000	LAVO01		\$20.00	0.0000	0	
	10		M6061T6S.050 sf		9/04/09	9/02/09	128.0000	\$2.88	0.0000	0	\$368.00 ✓
	No		6061-T6 .050 Sheet sf 112567		128.0000	LAVO01		\$368.00	0.0000	0	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10312

Purchase Order Date 9/01/09

PO Print Date 9/01/09

Page Number 1 of 4

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

FAKED
0209/01/09

Contact Name

Vendor Phone

800 363 6646

Vendor Fax

514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6B0.750X06.000	6061T6 BAR .750 X 6.00	9/04/09 Yes	✓ 60.00 f	Yours ppd 12/9/12	\$10.7500	\$645.00
Special Inst:			MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160 NEW 40				
2	✓ M6061T6B0.750X01.000	6061-T6 Bar .750 x 1.00	9/04/09 Yes	24.00 f	Yours ppd 12/9/12	\$3.0000	\$72.00
Special Inst:			AS ABOVE				
3	M6061T6B0.187X04.000	6061-T6 Bar .178 x 4.00	9/04/09 Yes	40.00 f	Yours ppd	\$1.7500	\$70.00
Special Inst:			AS ABOVE				
4	✓ M6061T6B0.750X00.750	6061-T6 Bar .750 x .750	9/04/09 Yes	✓ 40.00 f	Yours ppd 12/9/12	\$1.3500	\$54.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

M112567

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 9/01/09

Material Test Report

Customer Ship To:

Magna Stainless Inc.
5775 Kieran St.

St-Laurent

QB H4S 0A3

Our Order: 831165 - 2

Your PO # PO05960

Part # 05873-000-240

Die: LS05873

Description: .750 x 6.000

Alloy Temper 6061 T6

Print Date: 7/31/2009

Chemical Properties

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	others each	others total	Al
0.40-0.8	0.7 max	0.15-40	0.15 max	0.8-1.2	0.04-0.35	0.25 max	0.15	0.05	0.15	remain

Mechanical Properties

Strength ksi

Test ID	Test Date	CastNum	Ultimate	Yield (2% Offset)	Elongation (2" gage length)
1426	7/27/09	09050391A	44.04	40.51	19.5

S
07/07/02

Applicable Specifications: ASTM B221-08 ASTM B308-02 ASTM B429 QQA200/8 QQA200/16

Can Art Aluminum Extrusion Inc. certifies that materials shipped under this order have been inspected and tested in accordance with Aluminum Association and agreed upon customer specifications. Can Art assumes no liability for additional costs which may be incurred during the customer's manufacture and sale of its products, and is subject only to the replacement of any materials not within agreed upon specifications provided written notification is received by Can Art within 30 days from the date of shipment.

Eric Hotte - Tensile Testing

Authorized


Evan Eng, Quality Assurance Mgr.